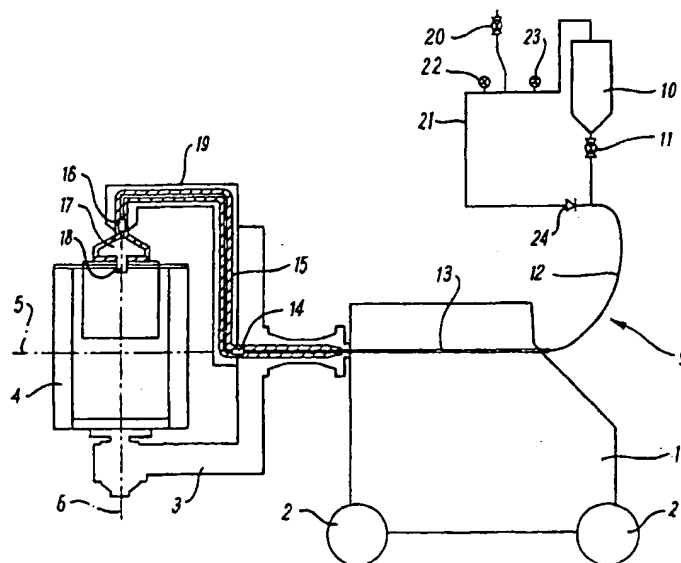




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(54) Title: METHOD AND APPARATUS FOR FEEDING MATERIAL INTO A ROTATING MOULD



(57) Abstract

Apparatus for rotational moulding comprises a feed hopper (10) pressurised by a compressed air supply (20) from which moulding powder may be fed under pressure via a line (12) to a mould (4). The feed line includes rotatable joints (14 and 16) which enables the mould to be rotated about two perpendicular axes, while material to be moulded is being fed to the mould. The apparatus and associated method reduce risk to operatives from inhalation of material, facilitate production of multilayer products and enable faster cycle times.

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METHOD AND APPARATUS FOR FEEDING MATERIAL INTO A ROTATING MOULD

The present invention relates to apparatus for and a method of rotational moulding.

Rotational moulding is a plastic processing technique used to
5 manufacture hollow plastic objects. A pre-weighed shot of material, determined by the desired wall thickness of the part, is placed in one half of a hollow sheet steel, cast aluminium or composite mould, which is mounted on a bi-axially rotating arm. The mould halves are closed and clamped together. The arm then moves into the oven where it is rotated
10 usually bi-axially to create a directed distribution of material on the internal surface of the mould. After the plastic has fully melted and consolidated, the arm moves out of the oven, into a cooling area, while still rotating bi-axially. Once the plastic has solidified and the mould is sufficiently cool to handle, the mould is unclamped and the part removed.

15 As previously stated, traditional mould 'charging' (adding the powdered plastic to the mould), involves weighing out an amount of material and pouring it into the mould. The mould is then clamped shut and the cycle starts.

It is an object of the invention to improve this traditional mould
20 charging method.

According to one aspect of the present invention, there is provided apparatus for rotational moulding comprising a mould, means enabling the

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mould to be moved and means for feeding material to be moulded to the mould during moulding.

According to another aspect of the invention, there is provided a method of rotational moulding including the steps of feeding moulding
5 material to a mould and simultaneously moving the mould in an oven.

In a preferred embodiment of the invention, the means for feeding material to be moulded comprises a feed hopper connected to the mould via a feed line. The movement of the mould may be a bi-axial rotation but other types of movement such as full or partial rotation about one axis or any
10 combination of these may also be used. The feed hopper is connected to a source of pressure, advantageously compressed gas such as air, via a pipe which incorporates control valves. Powdered moulding material is thereby carried on a stream of air under pressure to the mould. Liquid or granular material may also be used and a vacuum may be used to pull the material
15 along rather than pressure to push it. The pressure or vacuum may be steady or variable. For example, it may be pulsed. The feed line incorporates rotatable joints enabling rotation of the mould about the two transverse axes in relation to the surrounding. It also includes an insulated section to insulate the material passing through while in the mould and a
20 separating device which serves as a cyclone relieving air pressure in the system while at the same time directing polymer powder into the mould. Joints and feed line used may be those already fitted to some industrial

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rotational moulding machines.

In order that the invention may be more clearly understood, one embodiment thereof will now be described, by way of example, with reference to the single figure of the accompanying drawing which shows one form of rotational moulding apparatus according to the invention.

Referring to the figure, the apparatus comprises a carriage 1 mounted on wheels 2. Mounted on and extending from the front face of the carriage is a support 3 for a mould 4. The support 3 comprises an arm which is rotatably mounted for rotation about a horizontal axis 5. The mould 4 is mounted on the arm 3 for rotation about a vertical axis 6. In this way biaxial rotation of the mould 4 is provided for with respect to the carriage 2. Several moulds may be mounted on the same arm of any appropriate material such as sheet steel or cast aluminium. Composite materials may be used. Other types of movement than biaxial rotation may be employed, such as full or partial rotation about one axis or a combination of both. The objective is to create a desired distribution of material on the internal surface of the mould.

A material feed line 9 extends from a material feed hopper 10 through the carriage 1 and the support 3 to the mould 4. A valve 11 is disposed in this line just downstream of the feed hopper 10. The line comprises a flexible pipe 12 which leads into a rigid section 13 which extends through the carriage 1. From the trolley the line extends into the arm 3 and through

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a rotating joint 14 into an insulated section 15 of inverted J-shape at the other end of which is disposed a further rotating joint 16. On the downstream side of this rotating joint 16 is a separating device 17 and leads to a mould/system interface 18 which leads into the mould 4. The inverted
5 J-shaped section is provided with a system support and enclosure 19.

A compressed gas (such as air) system comprising a compressed gas supply (not shown) is provided to pressurise the material in the feed hopper 10 from which polymer powder is fed at a controlled rate into a pressurised air stream. The gas supply is connected via a valve 20 to a pipe
10 21 which is connected at opposite ends respectively to the top of the feed hopper and to the valve 11 on the downstream side. Isolator valves 22 and 23 are connected on opposite sides of the junction of the downstream side of valve 20 and pipe 21 and a non-return valve 24 is connected in pipe 21 adjacent to the junction of this pipe with the downstream side of valve 11.
15 The gas stream thereby provided in use carries material from the hopper under pressure through the feed pipe 9 into the mould while the mould is rotated biaxially about axes 5 and 6 inside an oven (not shown) into which the mould is advanced by the carriage 1. The cyclone separator unit is operative to relieve gas pressure in the system while at the same time
20 directing the polymer powder into the mould.

The pipework and rotatable joints used may be those existing in some industrial rotational moulding machines for pressuring the mould or for

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ducting an inert gas into the mould. Note that the plastic material may have its temperature controlled on the way to the mould.

There are a number advantages associated with this type of system:-

5 Elimination of the material charging stage - This minimises any risk to operatives from inhalation or dust explosions, as well as improving general tidiness in the moulding environment.

10 Multi-layer materials - Previously, creating multi-layered mouldings involved having to reverse the mould out of the oven and load a second shot (stopping both heating and rotation for this period), or the use of a 'drop box' which holds the second shot inside the mould and is remotely activated at the appropriate time (this however only allows one extra shot of material to be added).

15 Faster cycles - As well as the time increase associated with not having to charge the mould at the beginning of the cycle, the heating cycle is shortened as the polymer is added gradually (as opposed to having a single mass of polymer which is difficult to heat, due to the poor thermal conductivity of the plastic).

20 It will be appreciated that the above embodiment has been described by way of example only and that many variations are possible without departing from the scope of the invention. For example, although the invention has been shown applied to an offset arm machine it may be applied to any type of rotational moulding machine such as a straight arm

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machine. Other types of moulding material may be used for example, ceramic slurry or chocolate. The moulding material may be powdered, liquid or granular. Glass fibres may be fed to the mould. Although the moulded article will usually be removed from the mould after moulding, the mould

5 could form part of the final product. For example, the final product may comprise a metal shell coated with plastic. Vacuums may be used to pull the material into the mould rather than pressure to push it. The vacuum or pressure may be constant or may vary, for example it may be pulsed.

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CLAIMS

1. Apparatus for rotational moulding comprising a mould (4), means (3) enabling the mould to be moved and means (10) for feeding material to be moulded to the mould (4) during moulding.
- 5 2. Apparatus as claimed in claim 1, in which the means for feeding material to be moulded comprises a feed hopper (10) connected to the mould.
3. Apparatus as claimed in claim 2, in which the feed hopper (10) is connected to a source of pressure to push material from the hopper (10) to
10 the mould.
4. Apparatus as claimed in claim 3, in which the feed hopper (10) is connected to the source of pressure via a pipe (21) including a control valve (20) to provide means to for conveying moulding material to the mould on a stream of fluid.
- 15 5. Apparatus as claimed in claim 2, in which a source of vacuum to pull material from the feed hopper (10) and supply it to the mould (4).
6. Apparatus as claimed in claim 5, in which the feed hopper (10) is connected to a source of vacuum via a pipe (12) including a control valve (10) to provide means for conveying moulding material to the mould (4) on
20 a stream of fluid.
7. Apparatus as claimed in any of claims 3 to 6, in which the means (10) for feeding material to be moulded comprises means for maintaining the

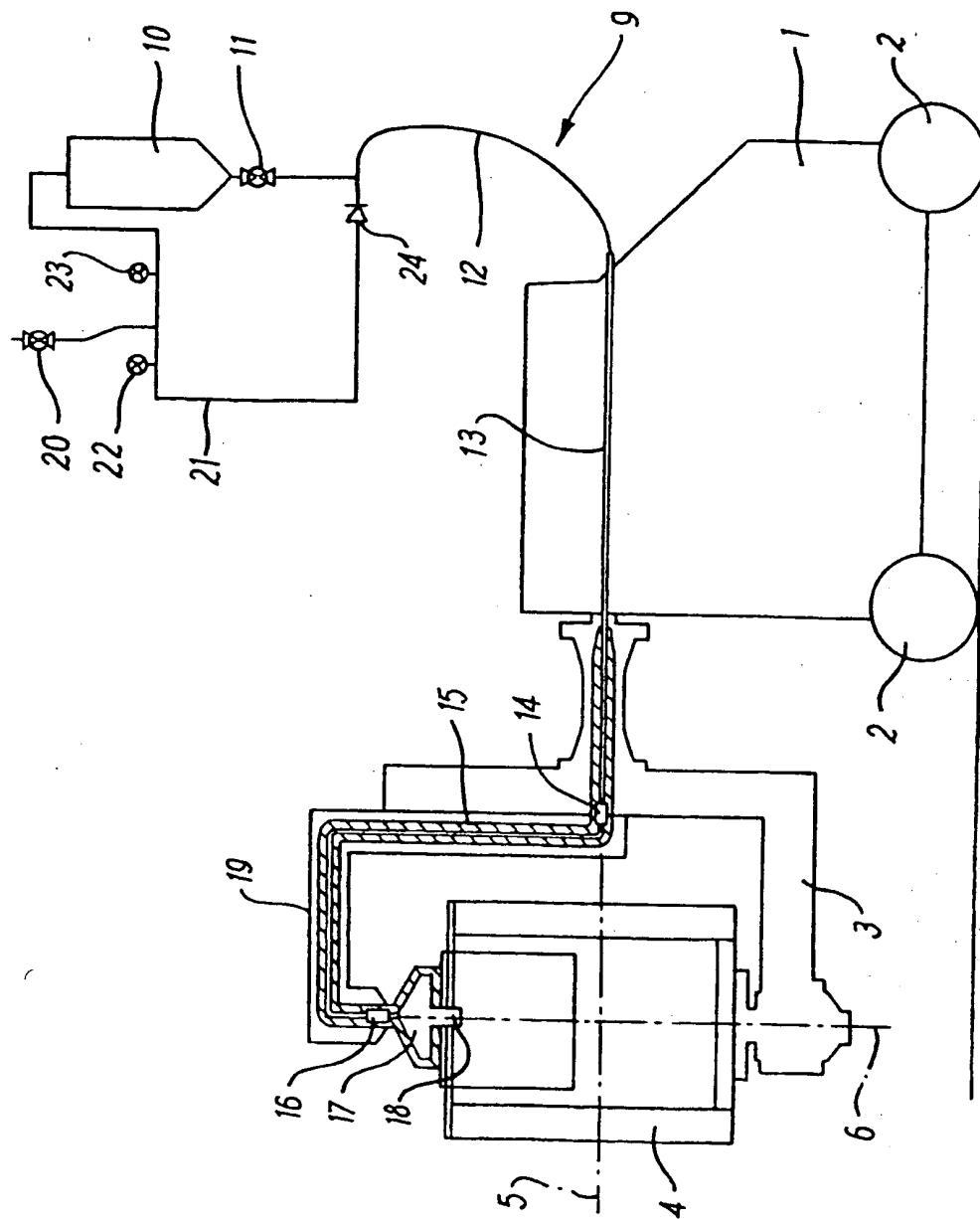
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pressure or vacuum steady.

- 5 8. Apparatus as claimed in any of claims 3 to 6, in which the means
 (10) for feeding material to be moulded comprises means for pulsing the
 pressure or vacuum.
9. Apparatus as claimed in any preceding claim, in which the means (10)
 for feeding comprises a feed line (12) incorporating rotatable joints (14,16).
- 10 10. Apparatus as claimed in any preceding claim, in which the means for
 feeding comprises a feed line (12) having an insulated section (15) to
 insulate material passing therethrough while in the mould (4).
11. Apparatus as claimed in any preceding claim, in which the means (10)
 for feeding comprises a separating device (17) serving as a cyclone relieving
 air pressure in the system whilst directly moulding material to the mould (4).
- 15 12. Apparatus as claimed in any preceding claim, in which the means (3)
 enabling the mould to be moved comprises means for producing a triaxial
 rotation.
13. Apparatus as claimed in any preceding claim, in which the means
 enabling the mould to be moved comprises means for producing full or
 partial rotation about one axis.
- 20 14. A method of rotational moulding including the steps of feeding
 moulding material to a mould and simultaneously moving the mould in an
 oven.

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15. A method as claimed in claim 14, in which the mould is rotated fully or partially about an axis.
16. A method as claimed in claim 14, in which the mould is rotated about two axes.



INTERNATIONAL SEARCH REPORT

International Application No

PCT/GB 98/03758

A. CLASSIFICATION OF SUBJECT MATTER
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According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

IPC 6 B29C

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practical, search terms used)

C. DOCUMENTS CONSIDERED TO BE RELEVANT

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X	AU 42099 96 A (AUTOMATED PLASTIC SYSTEMS PTY) 25 July 1996 see the whole document ---	1-4, 7, 9-11, 13-16
X	WO 96 16784 A (PAYNE LEROY) 6 June 1996 see the whole document ---	1-4, 7, 12-16
X	GB 1 128 608 A (DUNLOP COMPANY LTD) 25 September 1968 see page 3, line 38 - line 124 ---	1-3, 7, 13-15
X	FR 2 302 179 A (HALM RICHARD) 24 September 1976 see the whole document ---	1-4, 13-16
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☒ Further documents are listed in the continuation of box C.

☒ Patent family members are listed in annex.

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C.(Continuation) DOCUMENTS CONSIDERED TO BE RELEVANT

Category	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
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